Fermilab

Fermi National Accelerator Laboratory

Technical Division-Machine Shop

Welder Performance Qualification Record

Welder's Name	*Daniel Watkins*				**FNAL #**	*03991N*	**ASME #**	*24*	
Welding Process:	**1st**	*GTAW*	Type	*Manual*	**2nd**		Type		
Performed in accordance with:	*Fermi WPS SS-10-001*								

Joint:	~~Fillet:~~		~~Production Weld~~		***Test Coupon***		
Groove:	Double Welded:	~~Yes~~	No				
	Single Welded:	~~Metal Fused~~	~~Metal Non-Fused~~	~~Non-Metal~~	~~Open Root~~	~~Consumable Insert~~	
		~~With Solid Backing~~	Without Solid Backing		Square Butt Groove		

Base Metal:	Specification:	*SA213, Type 304/304L*	TO	*SA213,Type 304/304L*	*ASME P #8, Gp.1*	TO	*ASME P # 8, Gp1*
~~**Plate**~~		~~**Pipe**~~			**Tube**		
Actual Thickness:		Nominal Diameter:		Actual Diameter:		Overall Diameter:	*0.125"∅*
Qualified Range:		Wt/Schedule:		Qualified Thickness Range:		Wall:	*0.028"*
		Actual Thickness:		Qualified Diameter Range:		Qualified Thickness Range:	*0.028"-0.056"*
						Qualified Diameter Range:	*0.125"∅ Minimum*

Filler: ***No Filler-Autogenous***	**1st Process**		**2nd Process**	
Specification:	Class:		Specification:	Class:
Diameter(s):			Diameter(s):	
F #:			F #:	
Deposit Thickness:	Range Qualification:		Deposit Thickness:	Range Qualification:

Welding Position: *6G*	If Vertical: Up ~~Down~~				
Gas (Type & Composition:	Shielding: *Argon 99.99%*		Root Side Backing	Argon 99.99%	
Electrical Characteristics	Type Current	~~AC~~ ~~DCEP~~	*DCEN*		
	~~Transfer GMAW~~	~~Spray~~	~~Globular~~	~~Pulse~~	~~Short Circuit~~

Visual Inspection					
Appearance:	*Satisfactory*	Undercut:	*None Visually Observed*	Piping Porosity:	*None Visually Observed*

Guided Bend Test					
Type and Figure	Results	Type and Figure	Results	Type and Figure	Results
001:Cross Weld	*Weld-UTS 86,200*	*002:Face*	*Pass*	*004:Root*	*Pass*
		003:Face	*Pass*	*005:Root*	*Pass*
Test Conducted by: ***Exova Inc.***			Lab Test #: ***T017727***		Date: ***10/20/2010***

Radiographic Test			
Results:		Per ASME IX-2007	
Radiographer:	Examiner:	Test #:	Date:

Fillet Weld Test Results			
Fracture Test:	(Location, Nature, and size of Crack or Tear in Specimen)		
Length of Weld:	Length of Defect:	Percent of Defect	
Macro Test: Fusion			
Appearance: Fillet Size	inch X inch	☐ Convex	☐ Concave
Test Conducted by:		Lab Test #:	

Test Verified By:	Verification # *9102010-2-MR*	Date: ***9/10/2010***

We certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in accordance with the requirements of **ASME IX-2007 & AWS D1.1-06** ***Fermi National Accelerator Laboratory***

By: *Roger Hiller 00362N*	Date: ***9/10/2010***

Use of Fermilab Welding Procedures and Welder Qualifications for non-Fermilab work shall be at the sole risk and responsibility of the Subcontractor, and the Subcontractor shall indemnify and save Fermilab and the government harmless from any and all claims, demands, actions or causes of action, and for any expense or loss by reason of Subcontractor's and their employees possession and use of Fermilab procedures and qualifications.